

Work Order ID 61967

PRELIMINARY ISSUE

Monday, September 13, 2010 11:16:15 AM

Page 1

Item ID: D4173-5

Accept

Revision ID: PRELIM

Item Name: Pod Radalt Mounting Plate, LH

Start Date: 9/13/2010 Start Qty: 2.00

Required Date: 9/20/2010 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: HDate: 10-9-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4173

PAD 10.09.16

0.00



Waterjet

0.00

FLOW CNC Waterjet

6061 . 063

Memo

1-Cut as per Dwg

Dwg Rev: PMProg Rev: PM

2-Deburr if necessary

PAD same dim. as R110.09.16

③

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

Quality Control

10-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61967

Monday, September 13, 2010 11:16:15 AM



Item ID:	D4173-5	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pod Radalt Mounting Plate, LH					
Start Date:	9/13/2010	Start Qty:	2.00			
Required Date:	9/20/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 - inspected to PA-1 Dwg only 0.00 8/10/09/15 (23)							
130 Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00 JB 10/09/15				3			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 - inspected to PA-1 Dwg only 0.00 8/10/09/15 (23) - 55							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61967

Monday, September 13, 2010 11:16:15 AM



Page 3

Item ID:	D4173-5	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Pod Radalt Mounting Plate, LH					
Start Date:	9/13/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	9/20/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>LVA</u> Memo	0.00 0.00		<u>10-09-20</u>		<u>3</u>	<u>0</u>		
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/09/29</u> <u>AG</u>

10-09-20

POSITIVE RECALL
EFFECTIVE 10-09-13 AUTH U
RELEASED [Signature] DATE 10-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, September 13, 2010 11:16:19 AM

Page 1

Work Order ID: 61967

Parent Item: D4173-5

Parent Item Name: Pod Radalt Mounting Plate, LH


Start Date: 9/13/2010

Required Date: 9/20/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	101.4340	0.0814	0.171368			

UB 10-9-14

Location

Loc Qty

Loc Code

MAT21

101.434

113608

101.434

113608

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

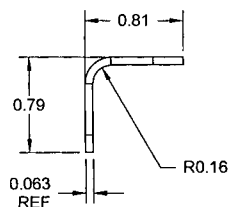
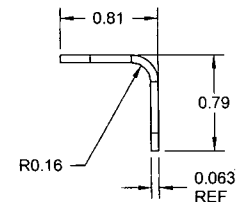
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

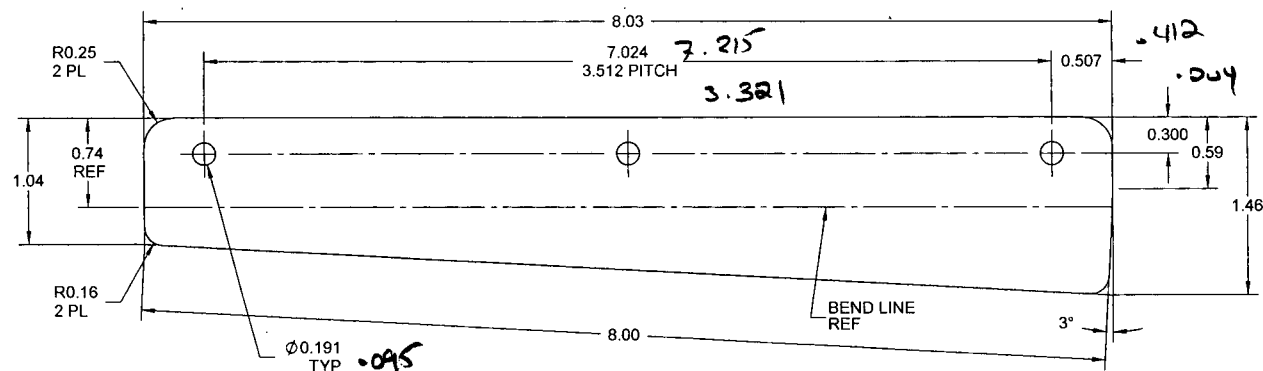
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D4173-5 POD RADALT MOUNTING PLATE, LH
MAKE FROM D4173-5F



D4173-6 POD RADALT MOUNTING PLATE, RH
MAKE FROM D4173-5F



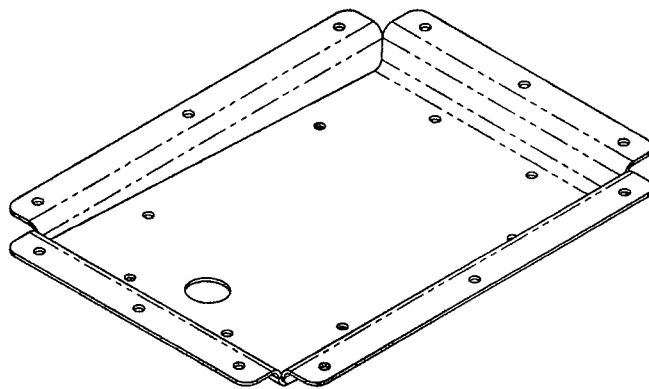
D4173-5F POD RADALT MOUNTING PLATE FLAT PATTERN 1

PRELIMINARY ISSUE
10.09.08

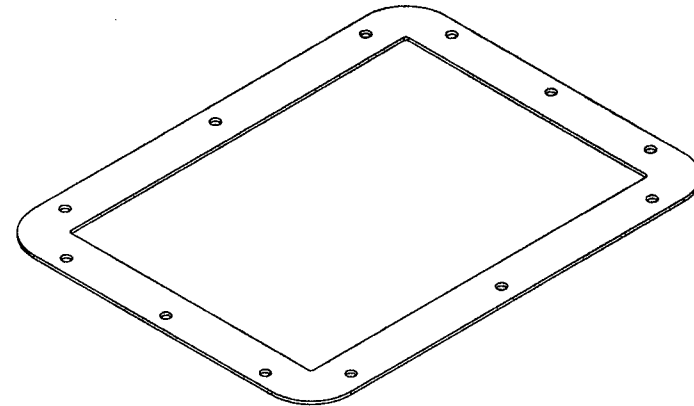
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- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs EACH

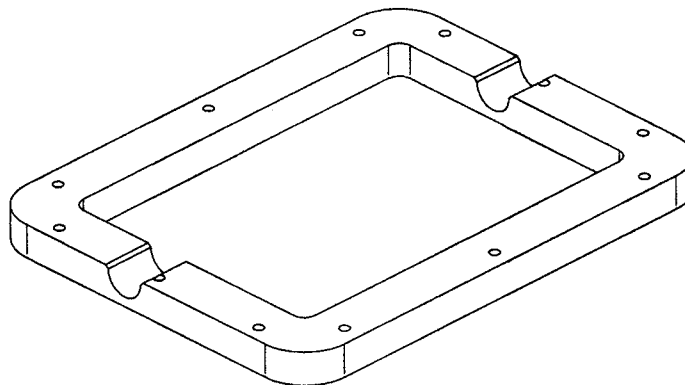
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DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA
MFG. APPR.		D4173	SHEET 6 OF
APPROVED		TITLE	SCALE
DE APPR.		POD RADALT MOUNTING PLATE ASSY NTS	
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D4173-041 POD RADALT MOUNTING PLATE ASSY



D4173-3 POD RADALT DOUBLER



D4173-7 RADALT SCHIM

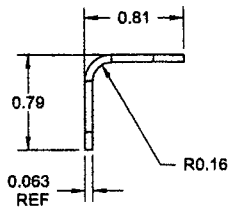
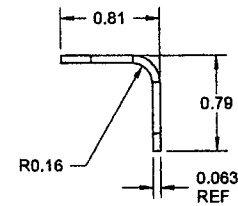
61967

PRELIMINARY ISSUE

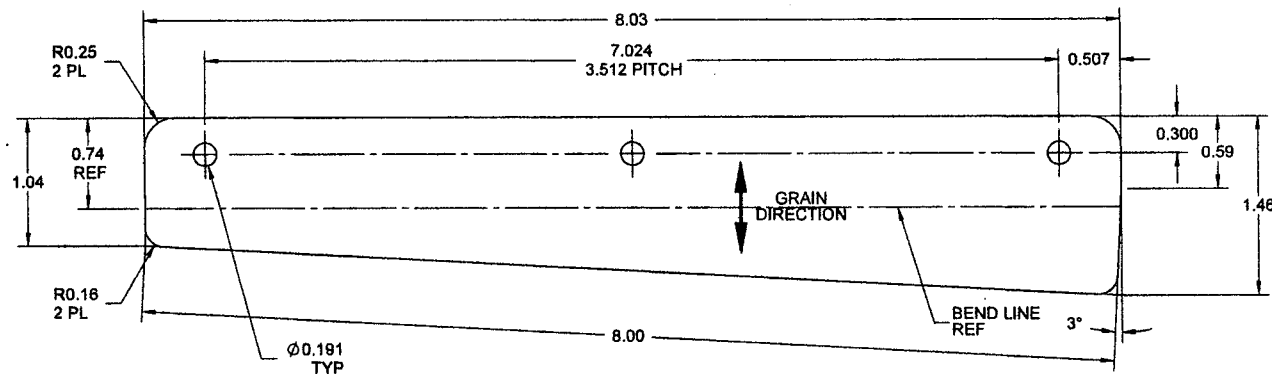
10.09.15

PA2	REVISED GROOVE IN D4173-7; ADDED TOL ON D4173-7 THICKNESS	MB	10.09.15
PA1	NEW ISSUE	MB	10.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4173	SHEET 1 OF 7
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DE APPR.		POD RADALT MOUNTING PLATE ASSY	NTS
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D4173-5 POD RADALT MOUNTING PLATE, LH
MAKE FROM D4173-5F



D4173-6 POD RADALT MOUNTING PLATE, RH
MAKE FROM D4173-5F



D4173-5F POD RADALT MOUNTING PLATE FLAT PATTERN

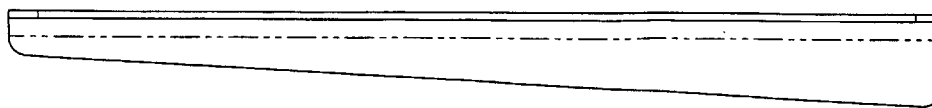
PRELIMINARY ISSUE
10.09.15

NOTES:

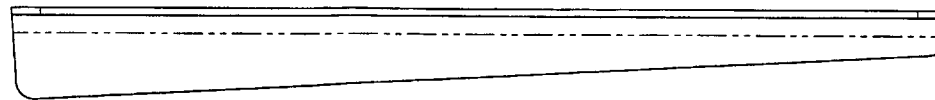
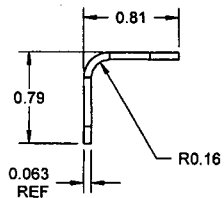
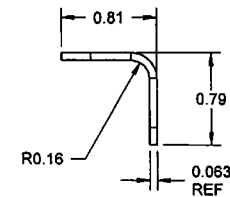
- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs EACH

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4173	SHEET 6 OF 7
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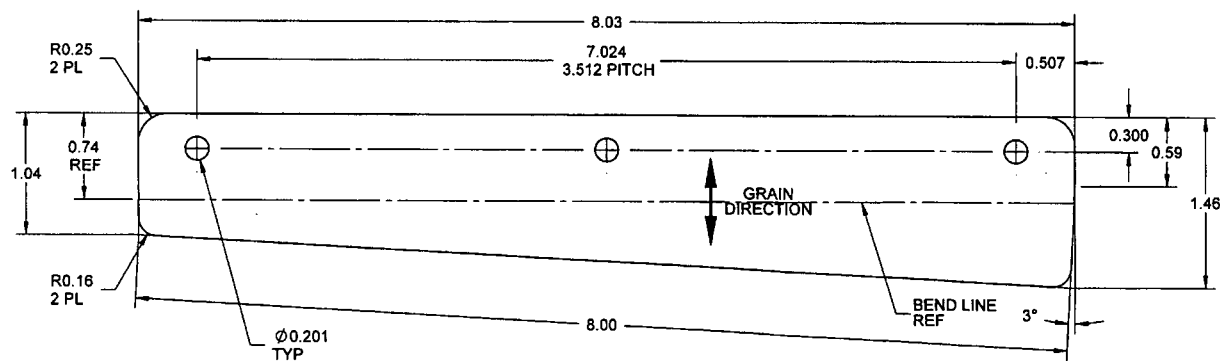
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D4173-5 POD RADALT MOUNTING PLATE, LH
MAKE FROM D4173-5F









D4173-6 POD RADALT MOUNTING PLATE, RH
MAKE FROM D4173-5F



D4173-5F POD RADALT MOUNTING PLATE FLAT PATTERN [1]

NOTES:

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MFG. APPR.		D4173	SHEET 6 OF 8
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61967

RELEASED
R 2010-09-29
AM

8 7 6 5 4 3 2 1